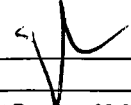


Date: Tuesday, 08/07/2008 1:46:55 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FORWARD GUIDE PLATE
 Job Number : 40373
 Estimate Number : 13365
 P.O. Number :
 This Issue : 08/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run : 05028
 Written By : 
 Checked & Approved By :
 Comment : Est Rev:A 08-06-05 new issue DD verified by:ec

Part Number : D35899
 Drawing Number : D3589 REV B PRELIM 08.07.14
 Project Number : N/A
 Drawing Revision : B PRELIM
 Material :
 Due Date : 15/07/2008 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0698 sf(s)/Unit Total: 0.0698 sf(s)

304/316 .063 Sheet

batch: 108090

IB 8-7-15
 ml 08 07 09

①

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3589

Dwg Rev: B prelim

Prog Rev: B prelim

IB 8-7-15
 ml 08 07 09

①

①

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-7-15
 ml 08 07 09

①

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING
 APPROVAL



Comment: SECOND CHECK

S 08/07/15 @

S 08/07/09 @

08.07.21

PTD

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

well

USED on D3589-041






B/N: PA0366

08.07.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3589-9 PAR #: N/A Fault Category: Eng / Design NCR: Yes No DQA: D Date: 09/02/19
 QA: N/C Closed: _____ Date: _____

NCR: <u>40373</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.06	5.0	PART WAS NOT ALIGNING PROPERLY UPON WELDING. MARK PART, REJECT ENG. + MAKE NEW PART BASED ON REVISED DWG.	 08.08.06	SCRAP MAKE NEW PART PER NEW DWG.	 08.08.06	 08/08/06	 08.08.06	 08/08/06

NOTE: Date & initial all entries

Date: Tuesday, 08/07/2008 1:46:55 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD GUIDE PLATE

Job Number: 40373

Part Number: D35899

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/17
JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.07.21

POSITIVE RECALL

EFFECTIVE 08.07.21 AUTH
RELEASED DATE 09.02.17

POSITIVE RECALL

EFFECTIVE 08.07.21 AUTH
RELEASED DATE 08.07.21

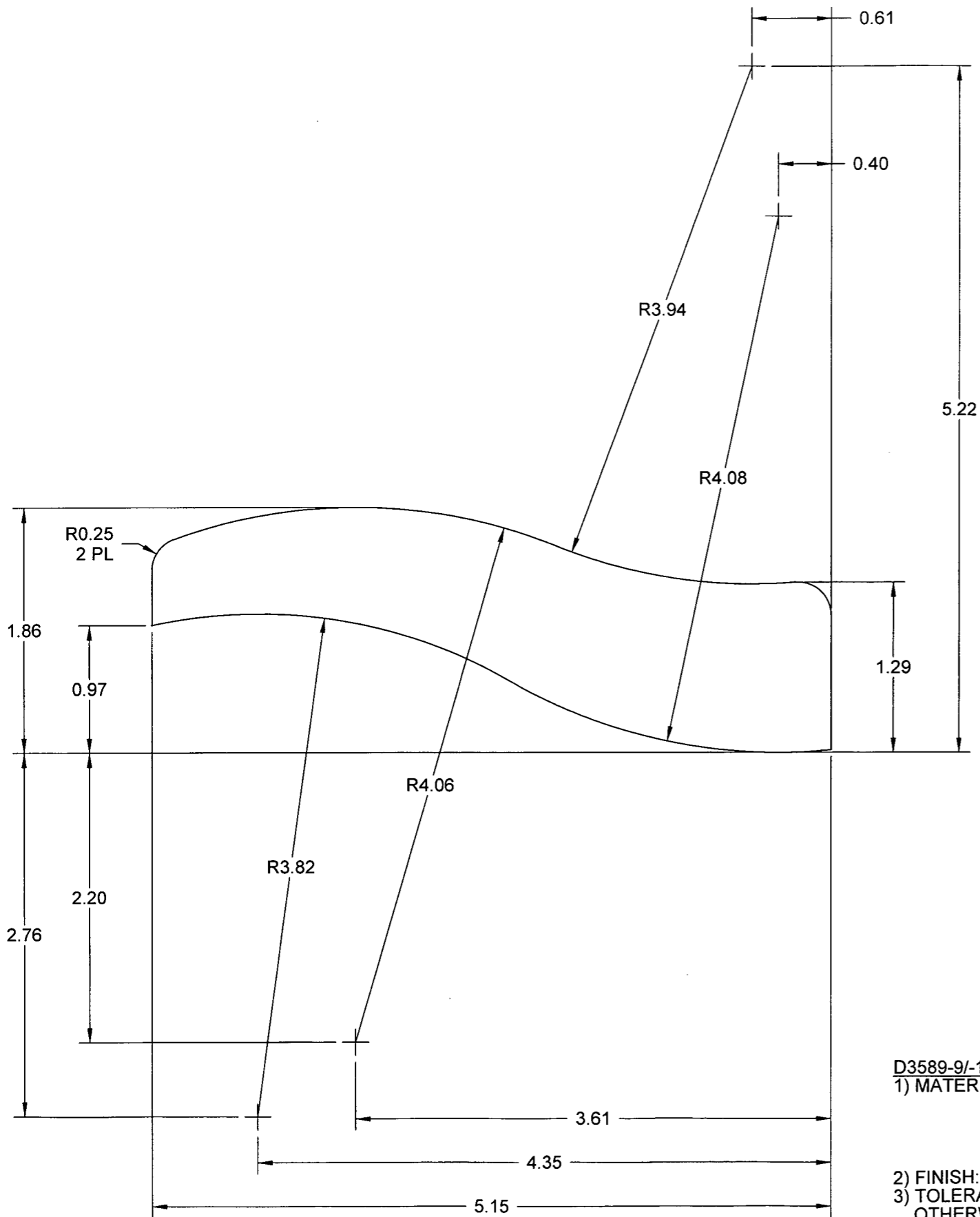
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

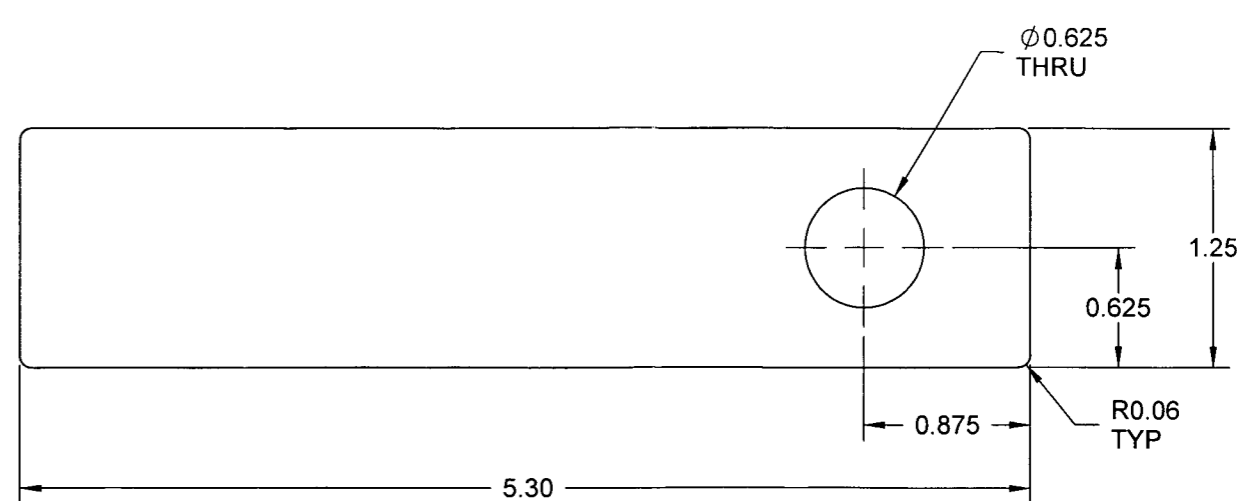
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

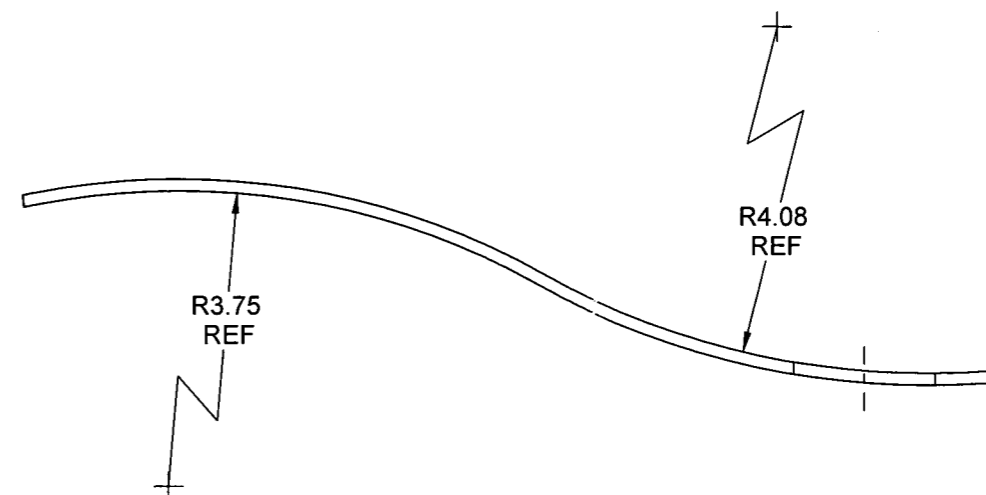
NOTE: Date & initial all entries



D3589-9 FORWARD GUIDE PLATE



**D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN**



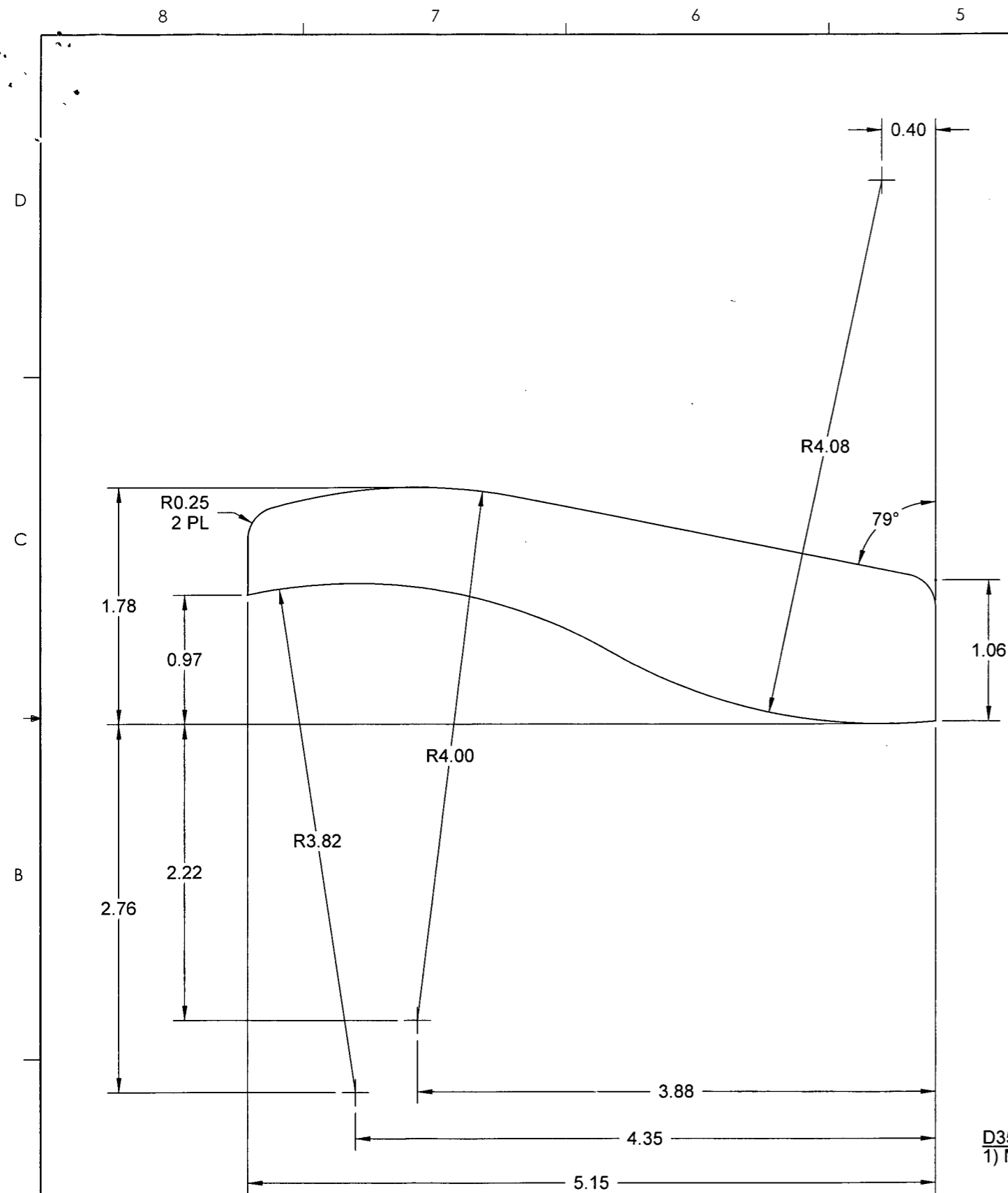
**8 D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)**

D3589-9/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

PRELIMINARY ISSUE
08.06.26

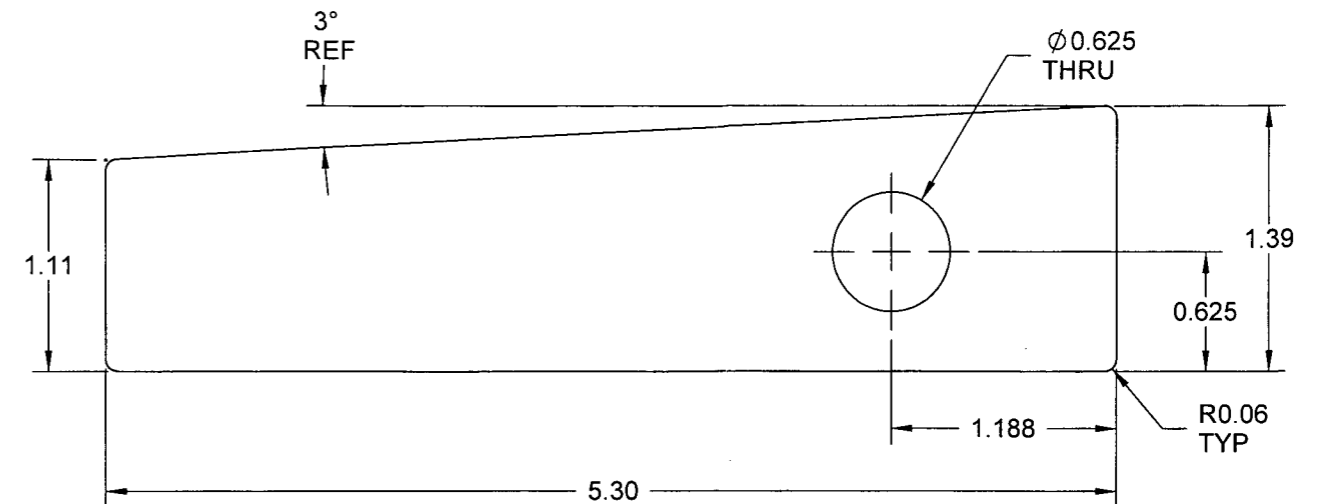
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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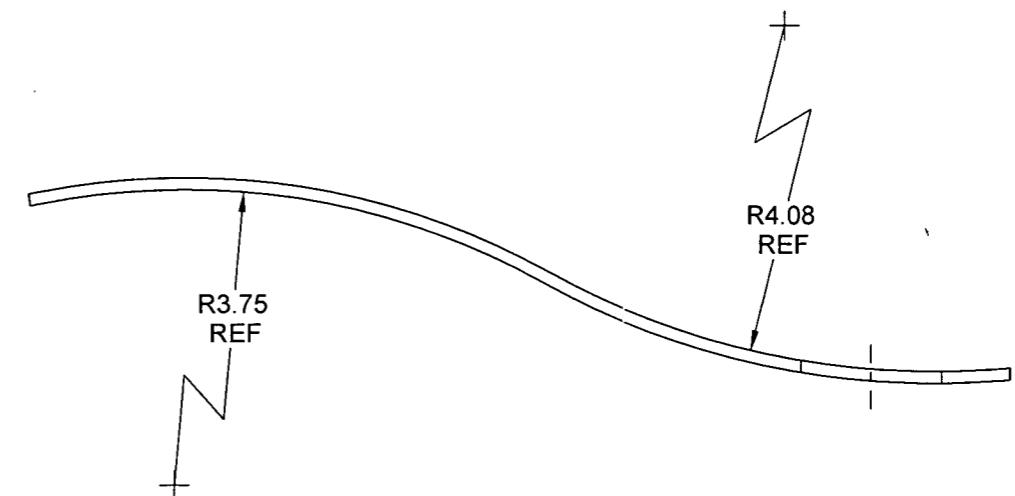
D3589-9 FORWARD GUIDE PLATE

D3589-9/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN

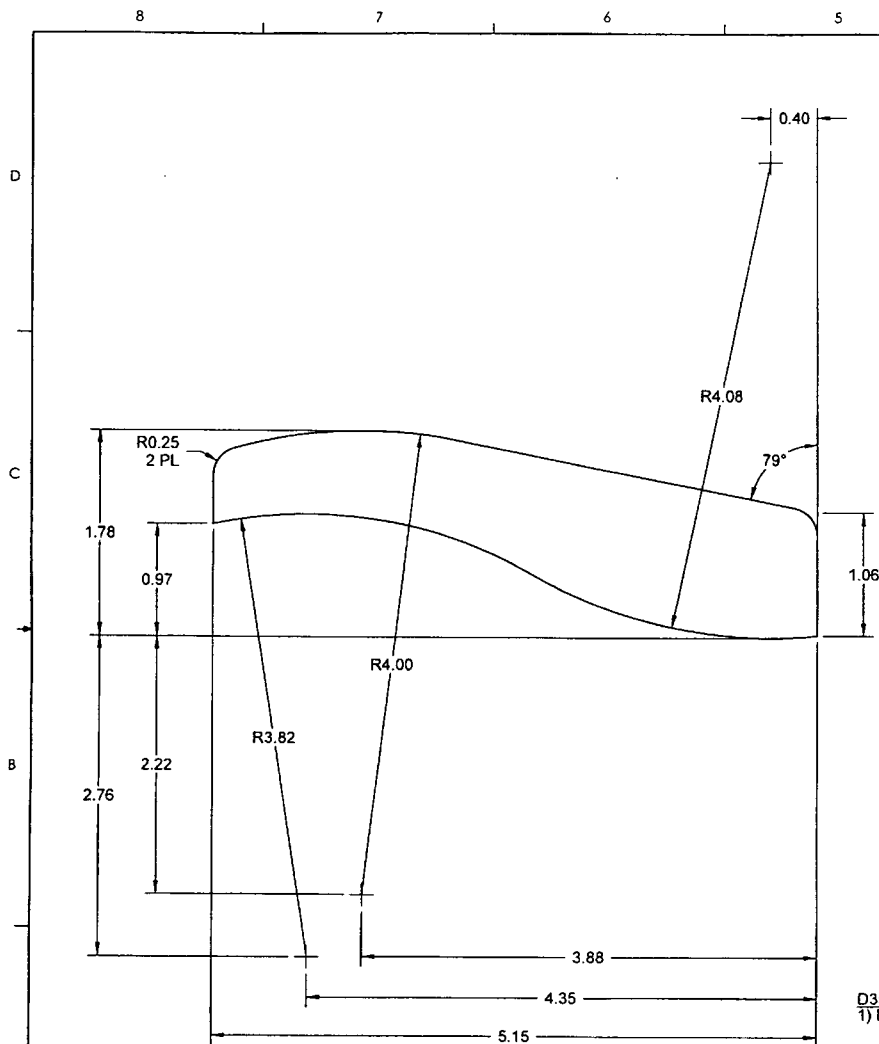


8 **D3589-11 FORWARD GUIDE PLATE**
(MAKE FROM D3589-11F)

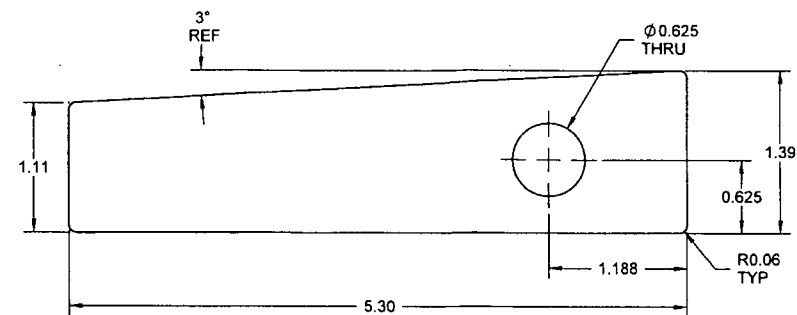
PRELIMINARY ISSUE

208.02.14

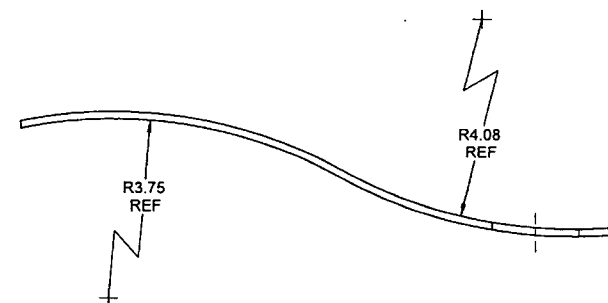
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3589	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FORWARD GUIDE PLATE	NTS
DATE	08.06.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3589-9 FORWARD GUIDE PLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

- D3589-9/-11/-11F NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs EACH
 - 8) CONTROL SHAPE PER DT9021 TEMPLATE

RELEASED
9/2/07

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3589	REV. B SHEET 5 OF 8
CHECKED		TITLE FORWARD GUIDE PLATE	
MFG. APPR.		SCALE NTS	
APPROVED		DATE 08.06.25	
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Date: Tuesday, 08/07/2008 1:46:55 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FORWARD GUIDE PLATE
Job Number : 40373
Estimate Number : 13365
P.O. Number :
This Issue : 08/07/2008 S.O. No. :
Prsht Rev. : NC Part Number : D35899
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3589 REV B PRELIM
Previous Run : 05028 Project Number : N/A
Written By : Drawing Revision : B PRELIM
Checked & Approved By : Material :
Due Date : 15/07/2008 Qty: 1 Um: Each
Comment : Est Rev:A 08-06-05 new issue DD verified by:ec

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0698 sf(s)/Unit Total: 0.0698 sf(s)
304/316 .063 Sheet
batch: 108090

HB 8-7-15
ml 08 07 09

①

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3589
Dwg Rev: B prelim
Prog Rev: B prelim

HB 8-7-15
ml 08 07 09

①

①

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-7-15
ml 08 07 09

①

4.0 QC8 SECOND CHECK



ENGINEERING
APPROVAL

Comment: SECOND CHECK

S 080715 @



S 080715 @

08.07.09

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

ml 08 07 09

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date May 22, 2008	Page 1
Receipt Number RCP00007949	

Purchase From:

Campi Steel
935 Boul. Du Havre
Valleyfield, QC J6S 5L1

REFERENCE ONLY

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-CAM002	PO00006375

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M1010B0750X025	ASTM A21 Steel .75"x	40.0000	f	6.250000	250.00	May 22, 2008
		OR CSA G40-21, 38W/44W/50W/60W/70W					
		MATERIAL: AISI 1010-1025 OR ASTM					
		A36/A366/A569/A570					
		B/N108090					
	M2024T3R1250	2024-T3 Round Bar 1.2	12.0000	f	10.950000	131.40	May 22, 2008
		PER AMS-QQ-A-200/8 OR AMS 4152/4164/4165					
		MATERIAL: 2024-T3 OR T3510/T3511 ALUMINUM					
		ROUND BATH					
		B/N108090					
	M2024T3S040	2024-T3 .040 sheet	96.0000	sf	8.750000	840.00	May 22, 2008
		PER QQ-A-250/4 OR AMS 4037					
		MATERIAL: 2024-T3 ALUMINUM SHEET					
		B/N108090					
	M2024T3S063	2024-T3 .063 sheet	96.0000	sf	14.150000	1,358.40	May 22, 2008
		AS ABOVE					
		B/N108090					
	M304S16GA	304/316 .063 Sheet	96.0000	sf	9.250000	888.00	May 22, 2008
		PER MIL-S-5019 ANNEALED 2B FINISH					
		MATERIAL: AISI 304/316 SS SHEET					
		B/N108090					
	M6061T6TS1250W	6061T6 SQ TUBE 1.25	20.0000	f	2.250000	45.00	May 22, 2008
		PER AMS-QQ-A-200/8 OR AMS 4160					
		PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR					
		SQUARE TUBING					
		MATERIAL: 6061-T6 OR 6061-R651/T6510/T6511/T62					
		B/N108090					

Comments:

WILL TEST CERTIFICATE

THE MAY COMP.

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED
DATE 08-14-2010 BY 60322 UCBAW

ALICE BOE ARTHUR 12601450

11514. 14240. 17430

SECRET

ORIGINAL

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[illegible]